

RIMCONOX 308L

Stick Welding Electrode for Stainless Steel
(Low C, 18% Cr, 8% Ni)

APPLICATIONS & CHARACTERISTICS

RIMCONOX 308L is lime titania type electrode for welding of 18% Cr-8% Ni stainless steel (AISI 301, 302, 304, 308). Excellent welding efficiency because of high deposition rate.

NOTE ON USAGE

- Redry the electrodes at 250 ~ 350°C for 30~60 minutes prior to use.
- Clean up the contaminations (water, rust, oil) from the groove prior to welding.
- Preheating is not necessary in general.

WELDING POSITIONS

PA, PB, PF, PC, PE

TYPICAL CHEMICAL COMPOSITION OR ALL WELD METAL (%):

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.03	0.84	0.80	0.023	0.016	19.38	9.6	0.2	0.3

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS N/mm ²	TS N/mm ²	EL %
430	600	44

ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE POLARITY : AC OR DC +

Dia (mm)	2.6	3.2	4.0
Length (mm)	350	350	350
Amps.	50~80	90~130	110~150

AWS A5.4-06 E308L-16
EN 1600:1997 : E19 9 LR 12
JIS Z 3221 : ES 308L-16



RIMCONOX 309L

Stick Welding Electrode for Stainless Steel
(Dissimilar Joint Welding)

APPLICATIONS & CHARACTERISTICS

RIMCONOX 309L is lime titania type electrode for welding of 22% Cr-12% Ni stainless steel and heat resisting casting, welding of dissimilar steels such as Cr-Mo steel or Carbon steel to stainless steel. The deposited weld metal has austenite structure.

NOTE ON USAGE

- Redry the electrodes at 250 ~ 350°C for 30~60 minutes prior to use.

WELDING POSITIONS

PA, PB, PF, PC, PE.

TYPICAL CHEMICAL COMPOSITION OR ALL WELD METAL (%):

C	Mn	Si	P	S	Cr	Ni	Mo	Cu
0.03	1.34	0.71	0.027	0.013	23.7	12.6	0.2	0.3

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

YS N/mm ²	TS N/mm ²	EL %
480	600	40

ELECTRODE SIZES AND RECOMMENDED CURRENT RANGE POLARITY : AC OR DC +

Dia (mm)	2.6	3.2	4.0
Length (mm)	350	350	350
Amps.	50~80	80~110	110~150

AWS A5.4-06 E309L-16
EN 1600:1997 : E2312LR12
JIS Z 3221 : ES 309L-16



STANDARD PACKAGING :

2.6 mm Dia }
3.2 mm Dia } 5kg / PKT
4.0 mm Dia }

